

Work Order ID 132708

132708

Page 1

Thursday, May 07, 2015 2:55:55 PM

Item ID: D6101-001 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle Billet
 Start Date: 5/7/2015 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: CL Date: MAR 08 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6101	Rev B								

100 PURCHASING 0.00
 100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 28432
 a) Description: Aluminum billet
 b) 6.00" x 6.250" x 2.00" thick
 c) Tolerance on length are +0.030"/-0.000"/E+/-0.008"
 d) Grain direction along 6.00" length
 e) Material: 7075-T7351 (QQ-A-250/12)
 f) Material certification required
CL MAR 11 2015 40

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging
 Packaging
 Memo
 Ensure material certification is attached
40x SP15-06-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								☐ OTHER : _____																																							

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				40	0		ml 15/06/08
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D								
130	Identify as per dwg & Stock Location: MAT042	0.00				40	0		DAS 08 9-89
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT042								
140	QC21- Final Inspection - Work Order Release	0.00							JUN 11 2015
140									
QC	Memo	0.00							
Quality Control									

MLJ JUN 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Thursday, May 07, 2015 2:55:55 PM

Page 1

Work Order ID: 132708

132708

Parent Item: D6101-001

D6101-001

Parent Item Name: Saddle Billet

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B: 01.05.04New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001P

Purchased

No

110

Each

0.0000

1

40

D6101-001P

7075-T7351 2X6X6.25

40X 5015-06-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

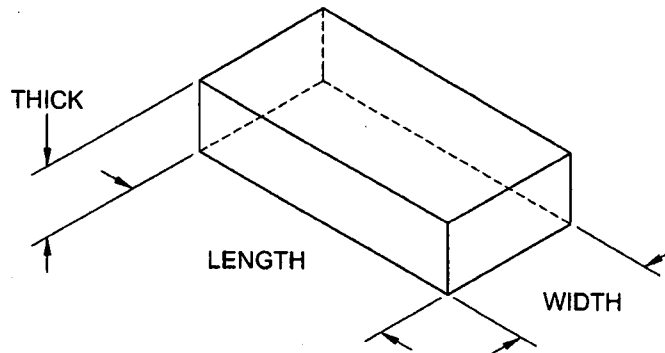
QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation		Disposition			

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Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WB

CY MAR 08 2015
w/0: 132708

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV..	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28432

Purchase Order Date 5/11/2015

PO Print Date 5/11/2015

Page Number 1 of 3

Order From :

VU-MET002

Ship To : DART AEROSPACE LTD.

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Yours ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D6101-001P	7075-T7351 2X6X6.25	5/20/2015		40.00	\$32.25	\$1,290.00
			Yes		Each		
			5/20/2015				

AS PER DWG D6101 REV. B

B132708

SIZE: 6.00" X 6.250" X 2.00" THICK

GRAIN DIRECTION ALONG 6.00" LENGHT

MATERIAL: 7075-T7351 QQ-A-250/12

TOLERANCE AS PER QUOTE +.030"/-.000"

SPS-06-08

Line Total:

\$1,290.00

2	D6101-003P	7075-T7351 2X6.25X7.875	5/20/2015		30.00	\$39.45	\$1,183.50
			Yes		Each		
			5/20/2015				

AS PER DWG D6101 REV. B

B132646

SIZE: 7.875" X 6.250" X 2.00" THICK

GRAIN DIRECTION ALONG 7.875" LENGHT

MATERIAL: 7075-T7351 QQ-A-250/12

TOLERANCE AS PER QUOTE +.030"/-.000"

Note:

5/11/2015

**Castle Metals®**

A. M. Castle & Co.

**BORDEREAU DE MARCHANDISES
CERTIFICAT DE CONFORMITE**

Page 1 of 2

No de Formulaire d'Emballage / Shipment No:2624953

Expédié de / Ship From:		Vendu à / Sold To:		Expédié à / Ship To:		Livré à / Deliver To:	
A. M. Castle & Co. (Canada) Inc. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date d'expédition / Date Shipped	F.O.B.	Modalités de transport / Freight Terms		Transporteur / Carrier		No du Bon de connaissance / BOL No	
04-JUN-2015	ORIGIN	Prepaid		MANITOULIN		2624953-2	

Détails d'expédition / Shipment Details	Destination finale / Final Destination Branch - MON
--	--

N° de commande / Order No		N° de ligne Line No		N° d'article / Item No		Description									
3861352		1		752237.MO		2.0000.PL.7075.T7351.ALUMINUM.USI. 6.25" X 6.00" CUT 2SIDED TO 6.25 IN () X 6 IN () SPECIFICATIONS: AMS-QQ-A-250/12									
N° de bon de commande / Purchase Order No		Nbre de pièces / Part Number		Qté commandée / Ordered Qty		Qté Facturée / Invoice Qty									
28432		YOUR ITEM NUMBER: D6101-001		40.00 PCS		40.00 PCS									
Détails / Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS SP15-06-08.													
N° de livraison / Delivery No :		Usine / Mill		No de coulée / Heat Number		Code méc / Mech Id		Qty or PCS		Largeur / Width (IN)		Longueur / Length (IN)		Qté expédiée/ Shipped Qty(LBS)	

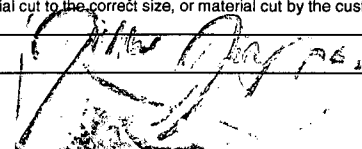


Castle Metals®

A. M. Castle & Co.

**BORDEREAU DE MARCHANDISES
CERTIFICAT DE CONFORMITE**

Page 2 of 2

120075975		40	309.6638
Ces marchandises/technologies sont sujettes aux règlements de l'Export Administration et du département d'état des États-Unis. Si elles ont été/sont exportées, elles doivent se conformer à ces règlements. Toute modification du contrat de transport contraire aux lois des États-Unis est interdite. These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited. Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit. We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A. M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit. Ce matériel a été reçu et inspecté par Reviewed by Authorized Castle Metals Representative:			
		Date: 4 JUN 2015	Name: 

SHIP TO:
SOLD TO:

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4372387

CUSTOMER PO NUMBER: 068630	WORK PACKAGE:	CUSTOMER PART NUMBER:	SHIP RUN/LOAD: 103179/17	GOVT CONTRACT NUMBER:
KAISER ORDER NO: 1188041	LINE ITEM: 5	SHIP DATE: 16-APR-2016	ALLOY: 7075	CLAD: BARE
TEMPER: T7351		PRODUCT DESCRIPTION: KaiserSelect Plate		
WEIGHT SHIPPED: 7148 LB	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2053444	GAGE: 2.0000 IN (50.8000 MM)	DIAMETER/WIDTH: 60.500 IN (1538.7 MM)
		LENGTH: 144.500 IN (3670.3 MM)		

MHU 1884261: LOT 12378980 2 pieces;
MHU 1884262: LOT 12378980 2 pieces;

Certified Specifications

AMS 4078/RevJ
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
MMS 159/RevT

AMS-QQ-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevU
GAMPS 9101/RevB/AmdSCN1
PPS 20.04/Rev7

AMS-STD-2154/RevA
BAC 5439/RevJ
CSTI 006/RevE
GSS16100/RevG/Amd1
PS 21211/RevM

Test Code: 4297

Test Results

Lot: 12378980 Cast 768

Drop 27

Ingot 1

Melted in USA

(ASTM B617)
(EN 2002-1)

Tensile: Temper
T7351

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPa)
71.1 : 71.8
(490 : 495)

Yield KSI (MPa)
60.2 : 61.3
(415 : 423)

Elongation %
11.4 : 12.6

(ASTM E1004)
(EN 2004-1)

Conductivity %IACS :
(MS/M) :

40.2 Min
23.3 Min

40.2 Max
23.3 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.08	0.19	1.5	0.05	2.6	0.20	5.7	0.03	0.01	0.01	TOT 0.06



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ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

Metal represented by this test report was 100% immersion ultrasonically tested from one side with 3mm dead zones top and bottom and meets the Class A and Class B requirements of all specifications referenced on this test report. No surface marking of sonic indications is performed.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO-9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
- * was melted in the United States of America or a qualifying country per DFARS 225.672-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.226 for domestic content.
- * has been thermally processed in compliance with AMS 2772, where applicable.
- * is mercury free, within the limits of detection of ASTM E1261 (< = 1ppm).
- * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- * is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
- * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.



JAMES HEMENWAY, LABORATORIES SUPERVISOR

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-001
DATE: 15/06/08

PO / BATCH NO.: 28432/132708

MATERIAL CERT REC'D: yes
QUANTITY RECEIVED: 40
QUANTITY INSPECTED: 40
QUANTITY REJECTED: _____

THICKNESS ORDERED: 600X6.25X2.00
THICKNESS RECEIVED: 600X6.25X2.00
SHEET SIZE ORDERED: _____
SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL	☒	N	
CORRECT THICKNESS	☒	N	
PHOTO REQUIRED	Y	☒	
CORRECT MATERIAL	☒	N	
CORRECT REF # TO LINK CERT	☒	N	
CORRECT MATERIAL IDENTIFICATION	☒	N	
CORRECT M# ON THE MATERIAL	☒	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>QML</u>		SIGNED OFF BY: _____	
DATE: <u>15/06/08</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER